

Work Order ID 80601

80601

Page 1

February-23-12 2:53:27 PM

Item ID: D4277-5 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Rib
 Start Date: 24/02/2012 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 09/03/2012 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 12/02/23 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4277	D								

100 0.00
 100
 Large Fab Memo 0.00
 Large Fab 1- Cut tube as per dwg D4277
 2- Remove marking and deburr

110 0.00
 110
 QC Memo 0.00
 Quality Control QC6- Inspect dimensions to drawing

120 0.00
 120
 Packaging Memo 0.00
 Packaging Identify as per dwg & Stock Location: WA
 STOCK IN BASKET CELL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 80601***80601***

Page 2

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Item ID: D4277-5 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Rib
Start Date: 24/02/2012 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 09/03/2012 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

12/2/29 AJ
ME
2-02-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

February-23-12 2:53:34 PM

Page 1

Work Order ID: 80601

80601

Parent Item: D4277-5

D4277-5

Parent Item Name: Rib

Start Date: 24/02/2012

Required Date: 09/03/2012

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP Rev:A 10.11.12 new issue DD verf:EC
11.01.20 AS PER DWG REV.C DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304TS0.500W.049

Purchased

No

100

f

363.3973

2.1875

4.605263

M304TS0 500W 049

**

PC12.02.27

Square Tubing

Location

Loc Qty

Loc Code

MAT034

363.3973285

116610

0.8383

117721

0.3234

117999

2.43919739

118460

359.796431

4.605263

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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

D

D4277-1 RIB

D4277-3 RIB

D4277-5 RIB

C

C

B

B

D4277-7 RIB

D4277-9 RIB

D4277-11 RIB

RELEASED
2011-02-24
MD

SHO
RIFLE
IN
UNCONT
SUBJECT

WELD
WELD
NO - 80601 M.C.J.
12/02/23

D4277-19 RIB



REV.	DESCRIPTION	BY	DATE
D	CHANGED ANGLE FROM 71° TO 81° (B3-3)	SC	11.02.09
C	D4277-19 RIB ADDED, ADDITIONAL HOLES ADDED IN D4277-1	SC	10.12.23
B	RMV -13/-15/-17 (OBSOLETE); -3: 8.09 WAS 20.25 (C5-2); -9: 13.50 WAS 2.00 (B4-2); -5: 24.25 WAS 26.25 (B5-2)	CP	10.11.30
A	NEW ISSUE	SC	10.11.25
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4277 TITLE RIBS REV. D SHEET 1 OF 3 SCALE NTS	
DRAWN	SC		
CHECKED	JPH		
MFG. APPR.	JPH		
APPROVED	JPH		
DE APPR.	JPH	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DATE	11.02.09		

8 7 6 5 4 3 2 1

A

A

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

7

6

5

4

3

2

1

D

C

B

A

0.030 X 45°
CHAM, 8 PL

0.625

0.375

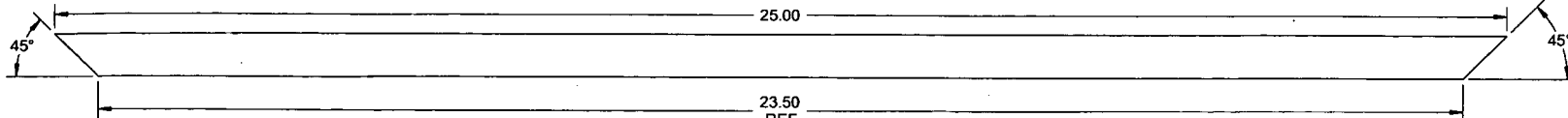
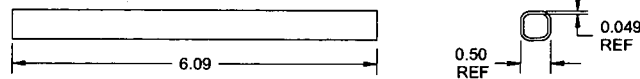
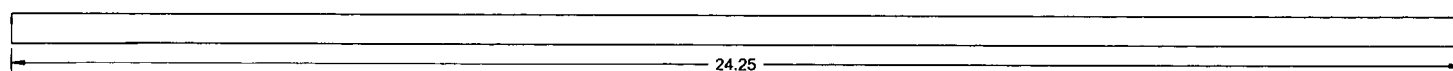
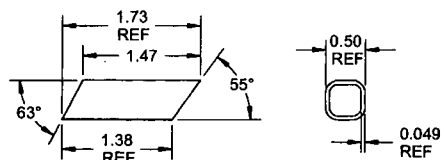
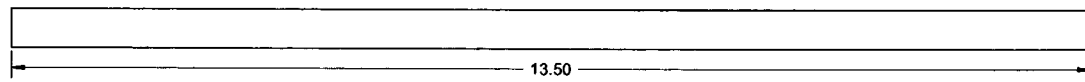
0.625

Ø0.38
THRU
4PL

6.35

8.10

800 01

**D4277-1 RIB****D4277-3 RIB****D4277-5 RIB****D4277-7 RIB****D4277-9 RIB**

RELEASED
2011-02-24

NOTES:

- 1) MATERIAL -1: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
-3, -5, -7, -9: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS.

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SK	DRAWING NO.	REV. D
MFG. APPR.	MD	D4277	SHEET 2 OF 3
APPROVED	MD	TITLE	SCALE
DE APPR.	SK	RIBS	NTS
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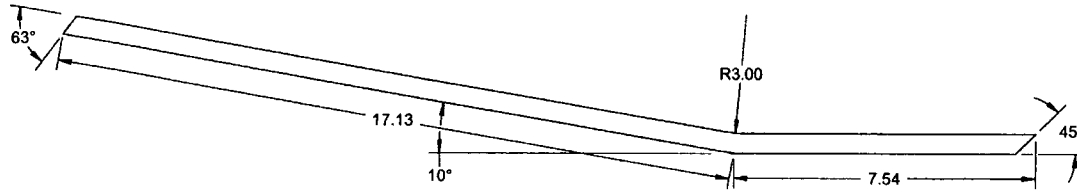
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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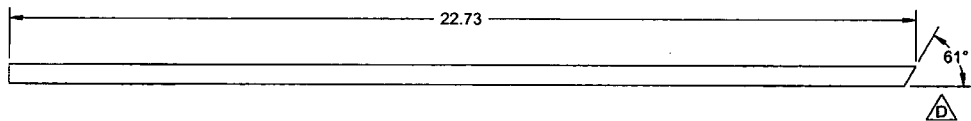
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NOTE: Date & initial all entries

80601



D4277-11 RIB



D4277-19 RIB

RELEASED
2011-02-24

NOTES:

- 1) MATERIAL -11, -19: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
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DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	K	DRAWING NO.	REV. D
MFG. APPR.		D4277	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIBS	NTS
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